



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5155-3
Job Sheet 197960



Part No: D5155-3

Job Qty: 5 pcs

Part Name: Co-Pilot Collective Head (212)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/16/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV.A NEW ISSUE JFS 15/01/14 VERIFIED BY: JLM IPP REV:B 15.07.02 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	8/16/19	8/16/19	0.00	0.19	Bandsaw - 1		#19-09-23
110	HAAS 5 Axis - B4B	5 pcs	8/16/19	8/16/19	0.78	14.29	HAAS - 5 - B4B		#19-09-23
120	QC 1	5 pcs	8/16/19	8/16/19	0.00	0.00	QC 1 - 14		
							QC 1 - 35		
							QC 1 - 8		
							QC 1 - 9		
130	QC 8	5 pcs	8/16/19	8/16/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 53		
							QC 8 - 8		B.A 19-10-01
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		



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Container No: S216400



Part: D5155-3

Job No: 197960

Serial No/Batch: S216400

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/23/19

Plex 7/18/19 3:07 PM Dart.lajeunesse.marie

				QC 8 - 57	
160 Packaging 3-1 - Stock - B4B 5 pcs	8/16/19	0.00	0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA 5 pcs	8/16/19	0.00	0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

OCT 07 2019

Part Op 100 - CUT BLANK AT 5.000"

Descriptions: 110 - (HAAS CNC vertical machine #5), MACHINE AS PER DWG & FOLIO FB349/ D5155-3

120 - (QC1- Inspection performed by CMM), Inspect on CMM as per folio CMMA032.

130 - (QC8- Inspect parts - second check)

160 - (Identify as per dwg & Stock Location: *W/60*)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B4.500X4.500 6061-T6 Aluminumbar 4.500" X 4.500" (CUT IN SECTION 6ft)		2.0850 ft (.417 ea)	100-Bandsaw - 1	S168973

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B4.500X4.500	2	11	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 197560
Description: Co-Pilot Collective Head (212)		Part Number: D5155-3
Inspection Dwg: D5155	Rev: B	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.33	+/-0.030	.327	✓		SLIO	Vein
0.06	+/-0.030	.061	✓			
0.35	+/-0.030	.345	✓		↓	
4.700	+/-0.010	4.700	✓			
2.800	+0.010/-0.000	2.804	✓		Height gauge	
R0.19	+/-0.030	.190	✓		Rad gauge	
0.35	+/-0.030	.351	✓		SLIO	
2.547	+/-0.005	2.549	✓		"	
21°	+/-0.5°	21°	✓		Protractor	
Ø0.125 x 0.350	+0.004/-0.001 x +/-0.010	.126 x .348	✓		SLIO	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.850	+/-0.010	1.845	✓		H-G-	
0.227	+/-0.010	.226	✓		SLIO	
Ø0.188 x 100°	+/-0.010 x +/-0.5°	.188 x 100°	✓			
Ø0.116	+0.004/-0.001	.118	✓			
1.188	+/-0.005	1.190	✓			
1.92	+/-0.030	1.915	✓			
1.50	+/-0.030	1.500	✓			
2.400	+/-0.005	2.400	✓			
0.300	+/-0.010	.300	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
Ø0.150	+0.005/-0.001	.155	✓		SLIO	
3.000	+/-0.010	3.000	✓		"	
R0.30	+/-0.030	.300	✓		Rad gauge	
R0.25	+/-0.030	.250	✓		"	
1.350	+/-0.010	1.349	✓		Height gauge	
1.750	+/-0.010	1.750	✓		"	
1.350	+/-0.010	1.349	✓		"	
1.00	+/-0.030	1.003	✓		"	
R0.25	+/-0.030	.250	✓		Rad gauge	
10°	+/-0.5°	10°	✓		Protractor	
0.25	+/-0.030	.251	✓		SLIO	
R0.30	+/-0.030	.300	✓		Rad gauge	
2.500	+/-0.010	2.500	✓		SLIO	
2.70	+/-0.030	2.701	✓			
Ø0.150	+0.005/-0.001	.153	✓			
Ø0.627	+0.008/-0.001	.628	✓			
Ø1.187	+0.005/-0.000	1.188	✓			
Ø1.660	+/-0.010	1.658	✓			

Entered: _____ Date: _____

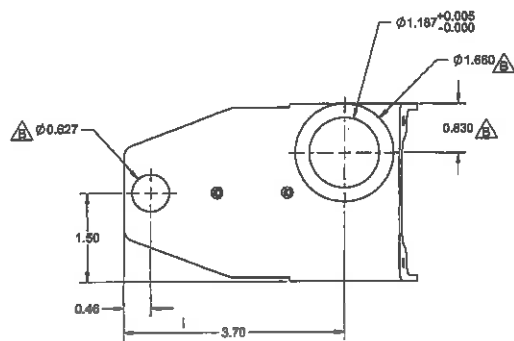
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

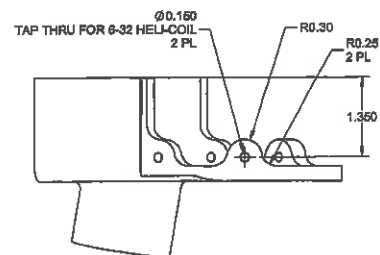
Route update only



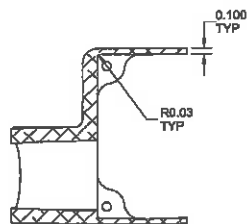
Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS1042)	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐				FAULT CATEGORY			
				Contamination ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐			
				Pressure/Forced ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐			
				Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐			
Other/Details: _____				Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐			
Completed By				Lead hand / Supervisor			
QC / QA Coordinator				QC / QA Coordinator			



VIEW G-G
86-7



VIEW H-H
D7-7



SECTION L-L
D6-7

RELEASED
4.9.2015 JUL 02

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 015 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

D5155-3 CO-PILOT COLLECTIVE HEAD (212)
DETAIL VIEWS

APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFB	D5155	SHEET 8 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	
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